

Work Order ID 57412

Page 1

April 6, 2010 3:09:20 PM

Item ID: D4054-001

Accept



Setup Start



Revision ID:

Item Name: Tube Assembly

Stop



Start Date: 4/06/10 Start Qty: 6.00



Cust Item ID:

Required Date: 4/12/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4054	A								

100 0.00



Small Fab

(6X)

Small Fab Memo 0.00

Small Fab Bend tube as per Dwg D4054

⇒ m-h 10/04/08

Install sleeves and nuts

Flare ends as per Dwg D4054.

110 QC5- Inspect part completeness to step on W/O 0.00



S 10/04/08

QC Memo 0.00

Quality Control

(OK)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57412

Page 2

April 6, 2010 3:09:20 PM

Item ID: D4054-001

Accept



Setup

Start



Revision ID:

Item Name: Tube Assembly

Stop



Start Date: 4/06/10 Start Qty: 6.00



Cust Item ID:

Required Date: 4/12/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

120



Identify as per dwg & Stock Location:

193

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Packaging

Memo

0.00

Packaging

130



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 3:09:19 PM

Page 1

Work Order ID: 57412



Parent Item: D4054-001



Parent Item Name: Tube Assembly

Start Date: 4/06/10

Required Date: 4/12/10

Comments: IPP rev A 10.01.19 new issue EC verified by:DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN818-8D		Purchased	No			100	Each	39.0000	12.0000			



Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST331 ✓

Loc Qty

39

Loc Code

12 X

m-h
10/04/08

M6061T6T0.500W.049



Purchased No

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

MAT014 ✓

Loc Qty

66.583

Loc Code

m-f
11-2421 10/04/08

MS20819-8D



Purchased No

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST323 ✓

Loc Qty

70

Loc Code

12 X m-f 10/04/08

Sleeve

112612 ✓

113795

20

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

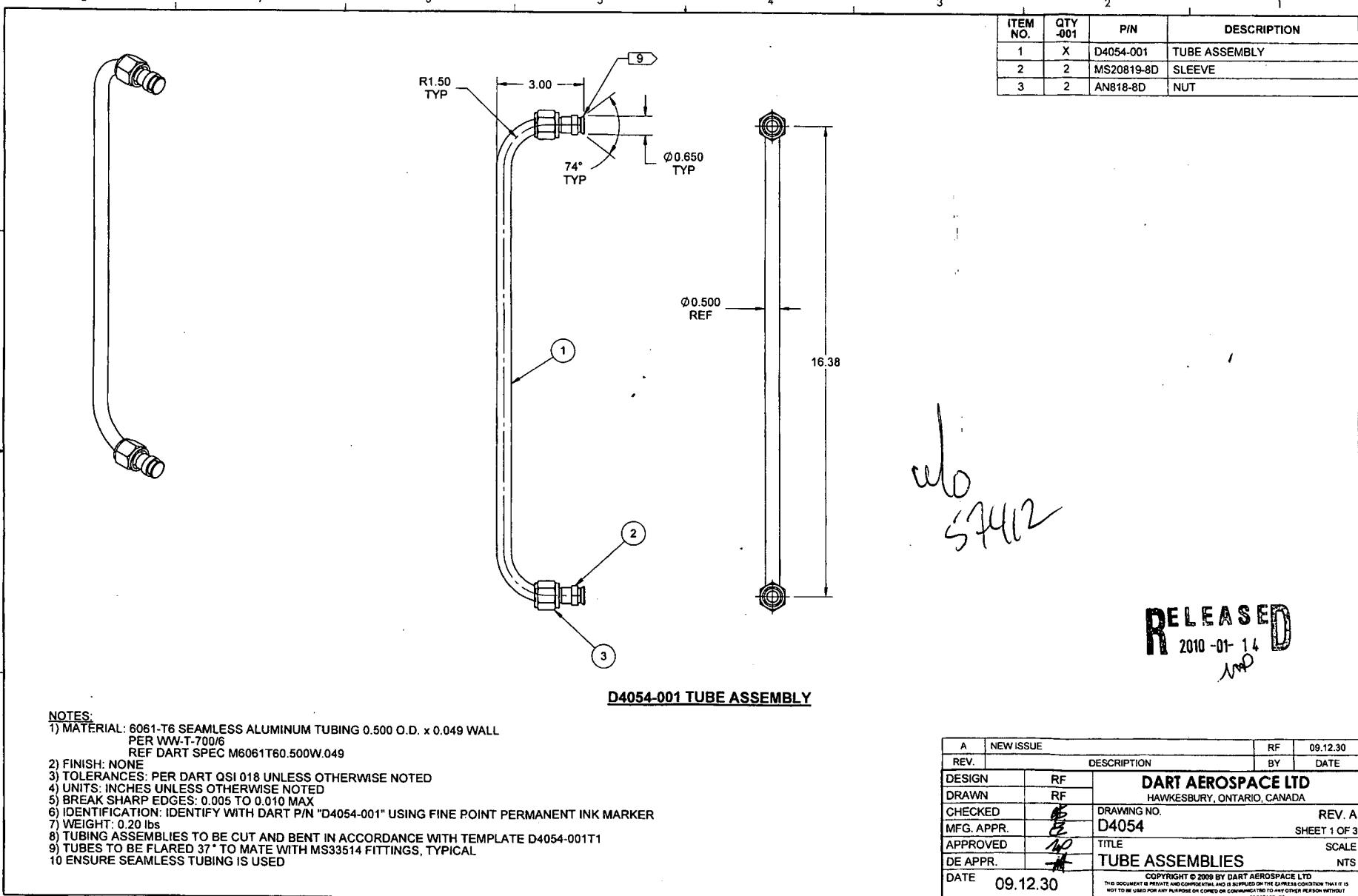
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

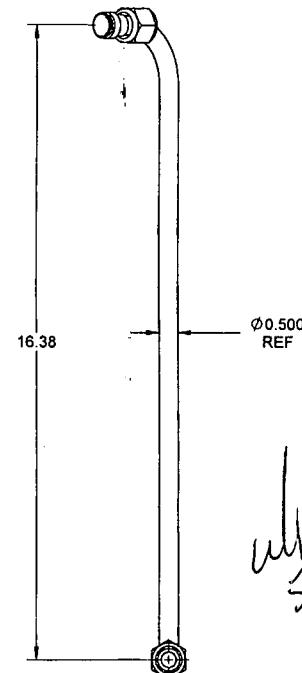
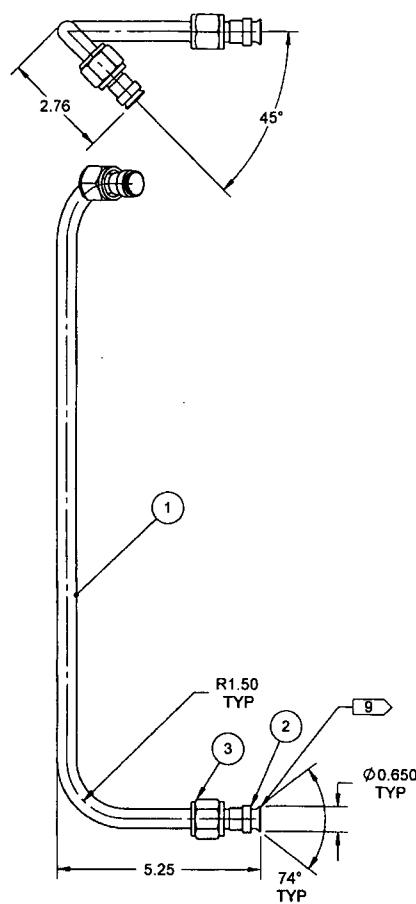
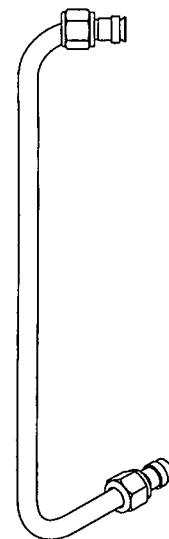
ITEM NO.	QTY	P/N	DESCRIPTION
1	X	D4054-001	TUBE ASSEMBLY
2	2	MS20819-8D	SLEEVE
3	2	AN818-8D	NUT

W
S7412

RELEASED
2010-01-14
W



ITEM	QTY 003	P/N	DESCRIPTION
1	X	D4054-003	TUBE ASSEMBLY
2	2	MS20819-8D	SLEEVE
3	2	AN818-8D	NUT



NOTES:
 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
 PER WW-T-700/6
 REF DART SPEC M6061T60.500W.049

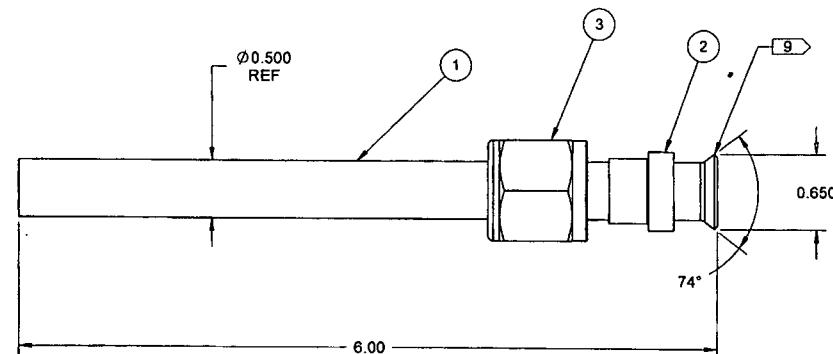
2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-003" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.21 lbs
 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-003T1
 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
 10 ENSURE SEAMLESS TUBING IS USED

D4054-003 TUBE ASSEMBLY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AE</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PE</i>	D4054	SHEET 2 OF 3
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	TUBE ASSEMBLIES	NTS
DATE	09.12.30	COPRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE WHATSOEVER BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
 2010-01-14
WW 57412
MP

ITEM	QTY	P/N	DESCRIPTION
1	X	D4054-009	TUBE ASSEMBLY
2	1	MS20819-8D	SLEEVE
3	1	AN818-8D	NUT



D4054-009 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-009" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-009T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS
- 10) ENSURE SEAMLESS TUBING IS USED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKSLEY, ONTARIO, CANADA	
CHECKED	<i>AB</i>	DRAWING NO.	
MFG. APPR.	<i>AB</i>	D4054	
APPROVED	<i>AB</i>	REV. A	
DE APPR.	<i>AB</i>	SHEET 3 OF 3	
DATE	09.12.30	TITLE	SCALE
		TUBE ASSEMBLIES	NTS

COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD

AB
5/24/12

RELEASED
2010-01-14
AB